

Work Order ID 74654

Wednesday, October 05, 2011 7:35:48 AM



ASAP

Page 1

Item ID: D3806-3

Accept



Setup Start



Revision ID:

Item Name: Bar

Stop



Start Date: 10/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date:

11-10-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3806

B

100

0.00



Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 49.70"

29 11.10.6

4

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB070 & dwg

FOLIO REV: 11

DWG REV: 12

2-Deburr as required

29 11.10.6

4

11/10/7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

20 11-10-6
10 11/10/7

4

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8-11-10-6

74

140

Identify as per dwg & Stock Location: *W/H*

0.00



Packaging

Memo

0.00

Packaging

PL 11-10-6

74

W/O:		WORK ORDER CHANGES					
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Wednesday, October 05, 2011 7:35:48 AM

Page 3

Item ID: D3806-3

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Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/w/n *
ME
11-16-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 05, 2011 7:35:45 AM

Page 1

Work Order ID: 74654

Parent Item: D3806-3

Parent Item Name: Bar



Start Date: 10/5/2011

Required Date: 10/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
 IPP Rev:B 08-09-23 redesign DD verified by:EC
 11.10.04 rev.b as per dwg DD verified by:EC

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.500X2.500

Purchased

No

100

f

13.0870

4.1

17.26316



304 BAR .500 x 2.50



20 11.10.6

should be
.250"

Location

Loc Qty

Loc Code

MAT050

13.087

112764

8.312

116135

0.375

117685

4.4

117159

16.566

not in system
 under 2.500 x .250
 (could not pull)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74654
Description: BAR		Part Number: D3806-3
Inspection Dwg:	Rev:	Page 1 of 1

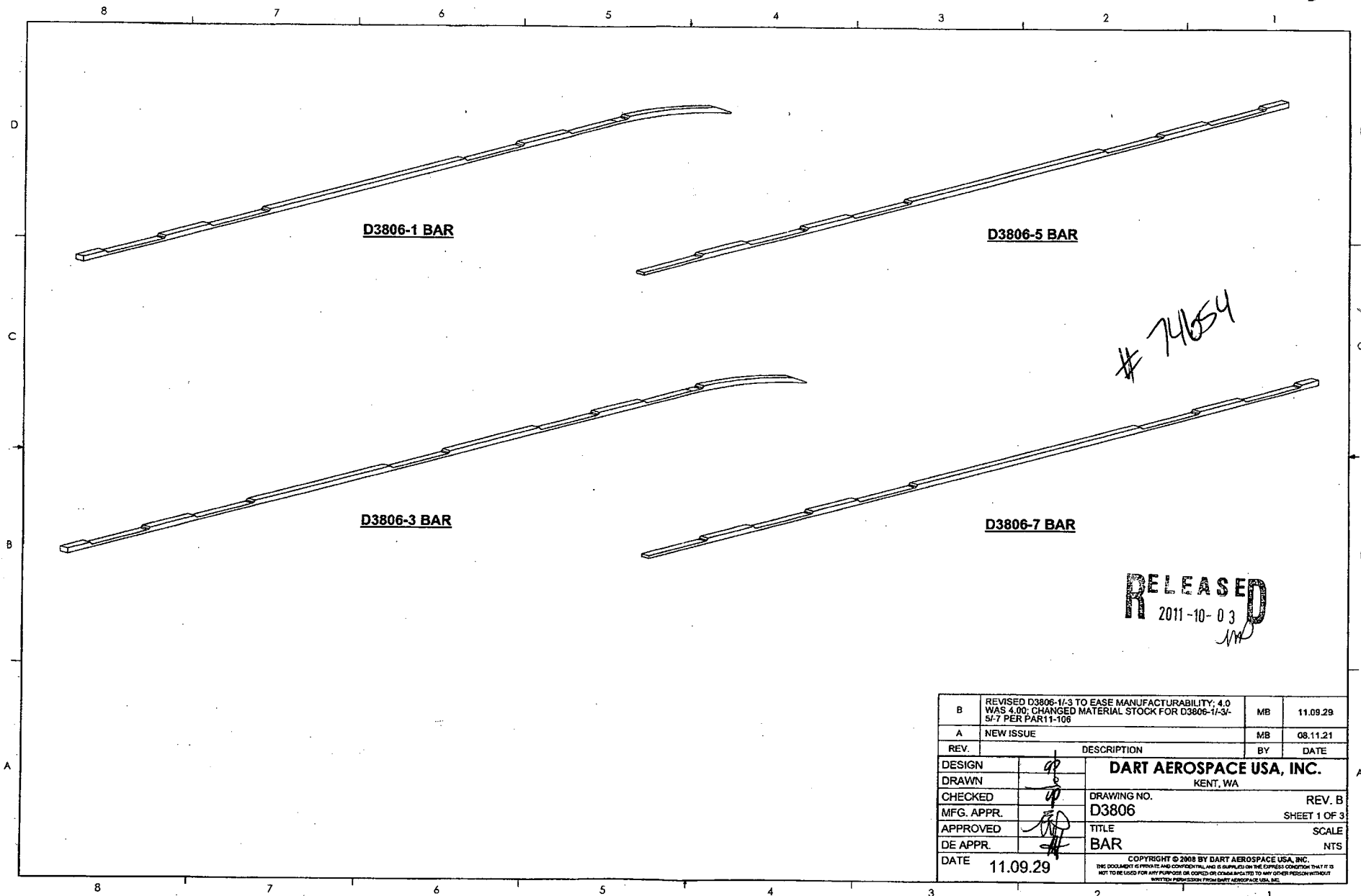
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.250	+/- .010	.255	✓		2R-52	
1.80	+/- .030	1.50	✓			
4.0	+/- .060	4.00	-			
8.80	+/- .030	8.80	-			
21.50	+/- .030	21.50	-			
31.80	+/- .030	31.80	-			
38.50	+/- .030	38.50	-			
1.00	+/- .030	1.00	-		RA04	Tape
1.12	+/- .030	1.12				
.050	+/- .010	.050				
.500	+/- .010	.500	-			
.050	+/- .030	.065	-		RA26	der 102
.130	+/- .010	.135	-			
.1350	+/- 1/2"	.135	-			
231.7	+/- .030	231.7				
49.70	+/- .030	49.70	-			
41.75	+/- .030	41.75				
49.60	+/- .030	49.60				

Measured by: R21	Audited by: S	Preliminary Approval:
Date: 11.10.06	Date: 11/10/07	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



B	REVISED D3806-1/-3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/-3/-5/-7 PER PART 11-106		MB	11.09.29
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC.			
DRAWN	KENT, WA			
CHECKED	DRAWING NO. D3806		REV. B	
MFG. APPR.	TITLE BAR		SHEET 1 OF 3	
APPROVED	SCALE		NTS	
DE APPR.	DATE 11.09.29		<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

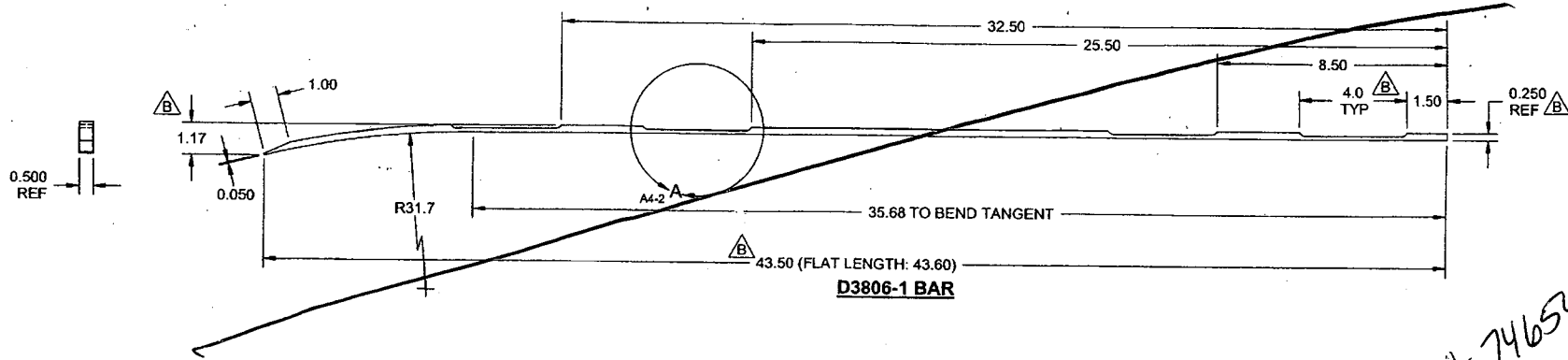
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

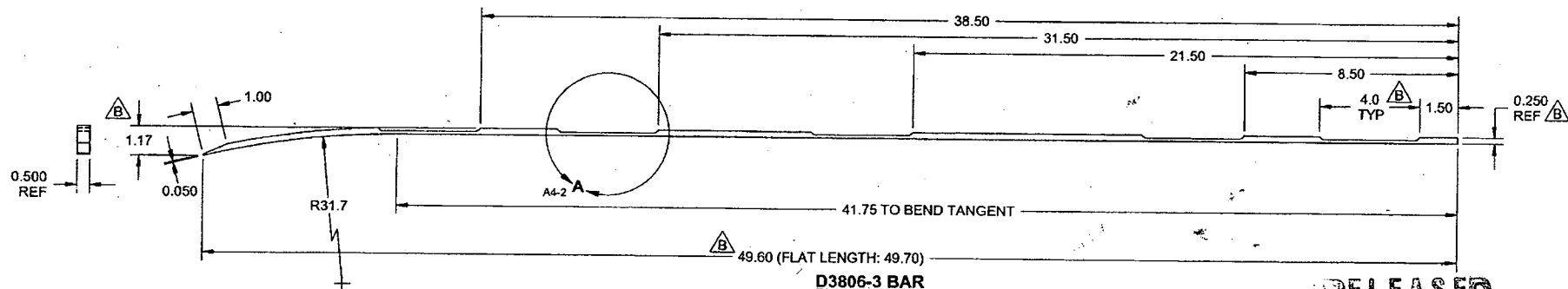
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3806-1 BAR

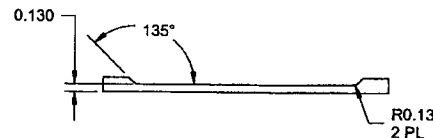


D3806-3 BAR

RELEASED
2011-10-03
JH

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs



DETAIL A
TYP, SCALE 2X

D5-2
B6-2
C3-3
A3-3

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3806	REV. B
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE BAR	SCALE NTS
DE APPR.			
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8 7 6 5 4 3 2 1

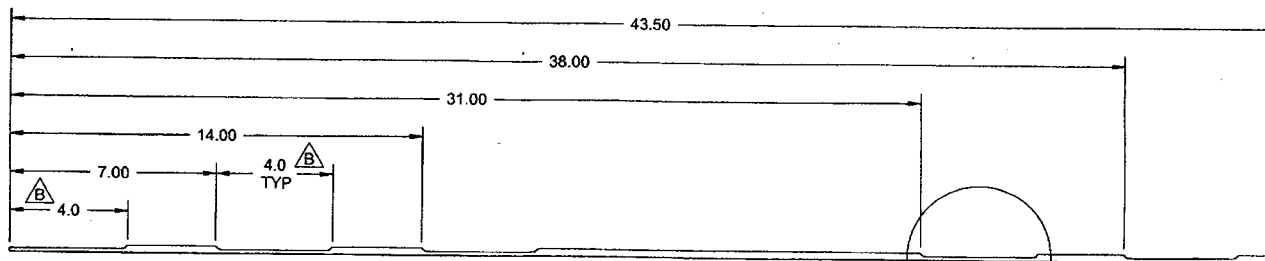
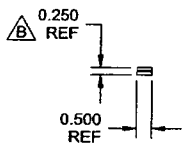
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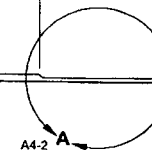
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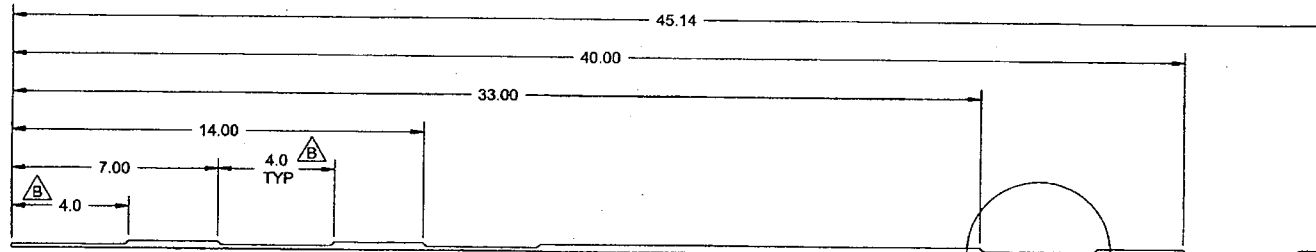
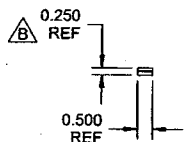
NOTE: Date & initial all entries



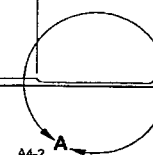
D3806-5 BAR



#74654



D3806-7 BAR



RELEASED
2011-10-03
MMP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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